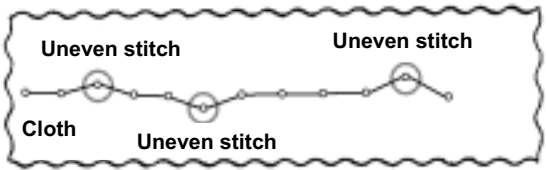
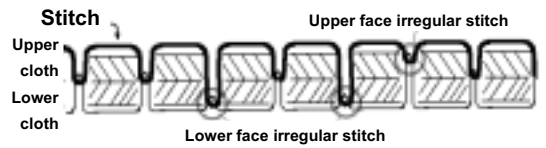
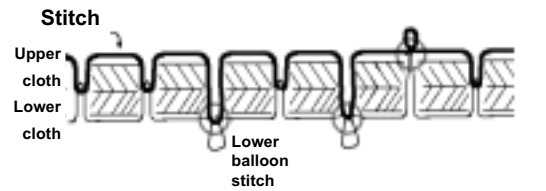
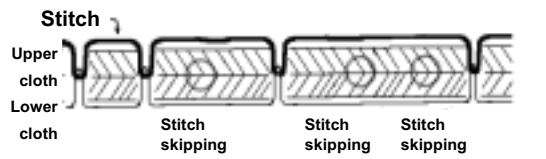

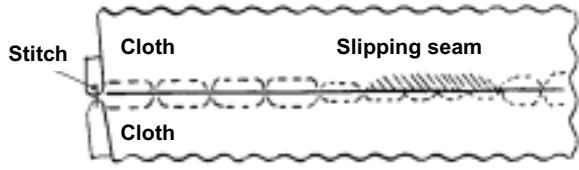
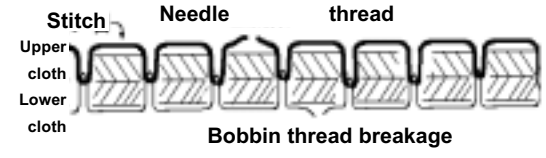
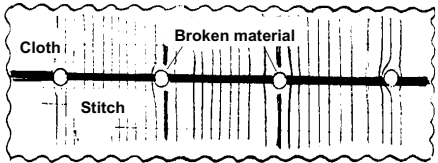
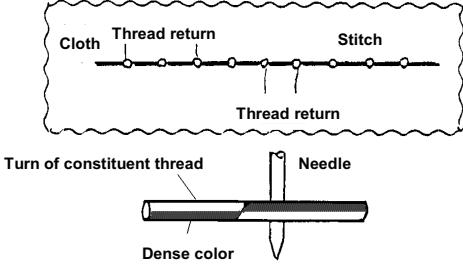
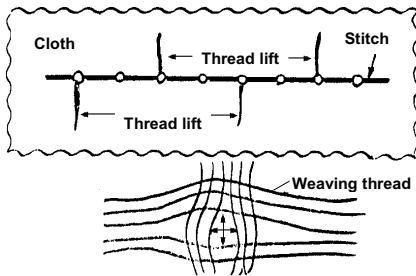
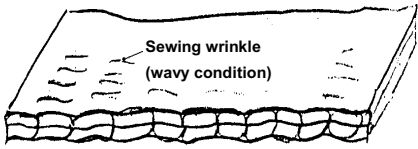
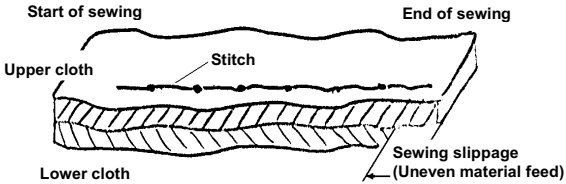
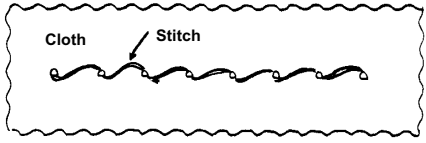
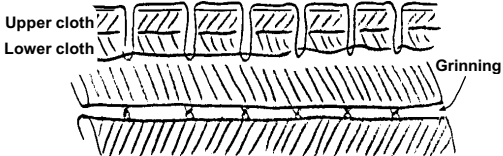
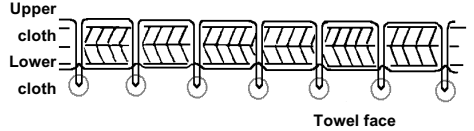
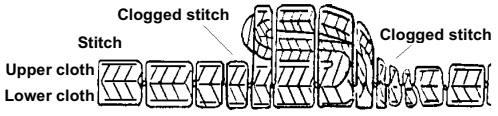
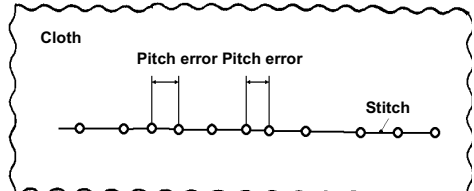
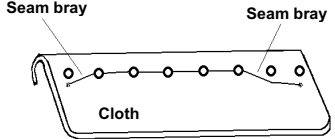
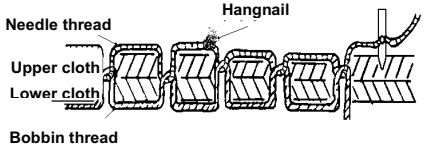
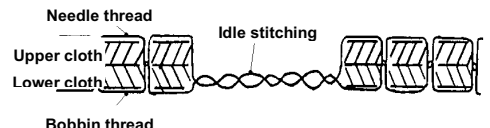
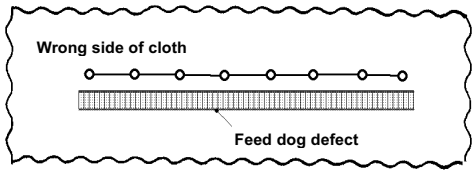
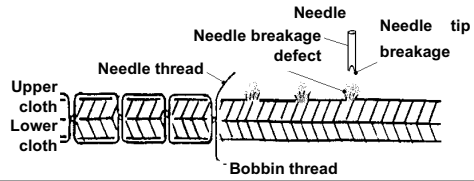
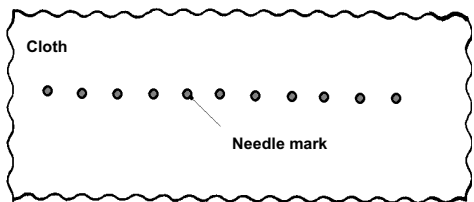


Defects of sewing that occur in sewing process and definition of terms

<Table IV-1>

| No | Term | Definition (contents) | Contents of defect |
|----|---|--|--|
| 1 | Uneven stitch | Stitching is not performed straight and a part of stitches is sewn in disorder. |  <p>Uneven stitch</p> <p>Cloth</p> <p>Uneven stitch</p> |
| 2 | Irregular stitch | Irregular knotting points of thread occur on upper and lower faces of cloths under a certain tightness |  <p>Stitch</p> <p>Upper cloth</p> <p>Lower cloth</p> <p>Upper face irregular stitch</p> <p>Lower face irregular stitch</p> |
| 3 | Balloon stitch | Large or small thread loop suddenly occurs on upper or lower cloth from knotting point of sewing thread. |  <p>Stitch</p> <p>Upper cloth</p> <p>Lower cloth</p> <p>Lower balloon stitch</p> |
| 4 | Stitch skipping | Stitches of sewing thread partially skip and stitching is not performed completely. |  <p>Stitch</p> <p>Upper cloth</p> <p>Lower cloth</p> <p>Stitch skipping</p> <p>Stitch skipping</p> <p>Stitch skipping</p> |
| 5 | Missing stitch | Stitches are out of the sewing line. |  <p>Uppercloth</p> <p>Lower cloth</p> <p>Missing</p> |
| 6 | Slipping seam (slipping) (slip-out) | When the force is applied to stitch, the constituent thread of the part moves and stitch opens or slips. |  <p>Stitch</p> <p>Cloth</p> <p>Slipping seam</p> <p>Cloth</p> |
| 7 | Thread breakage | When the force is applied to stitch, sewing thread is cut. |  <p>Stitch</p> <p>Needle</p> <p>thread</p> <p>Upper cloth</p> <p>Lower cloth</p> <p>Bobbin thread breakage</p> |

| No | Term | Definition (contents) | Contents of defect |
|----|--|---|--|
| 8 | Broken material | Constituent threads of cloth are cut by sewing machine needle at the time of sewing. |  <p>The diagram shows a cross-section of cloth with a horizontal thread. A sewing machine needle is shown passing through the cloth, creating a hole. The thread is broken at the point of penetration. Labels include 'Cloth', 'Broken material', and 'Stitch'.</p> |
| 9 | Thread return (Reverse) | The line that occurs when constituent thread of cloth turns and thread on the wrong side faces the right side by the shock force at the time of penetration of sewing machine needle. |  <p>The diagram shows a cross-section of cloth with a horizontal thread. A sewing machine needle is shown passing through the cloth, creating a hole. The thread is broken at the point of penetration. Labels include 'Cloth', 'Thread return', 'Stitch', and 'Thread return'. Below the diagram, a separate illustration shows a 'Turn of constituent thread' and a 'Needle' with a 'Dense color'.</p> |
| 10 | Weaving thread lift | The state that defective gloss or defective pattern occurs when a part of weaving threads is shifted by stitch, sewing machine needle, awl, etc. |  <p>The diagram shows a cross-section of cloth with a horizontal thread. A sewing machine needle is shown passing through the cloth, creating a hole. The thread is broken at the point of penetration. Labels include 'Cloth', 'Thread lift', 'Stitch', and 'Weaving thread'.</p> |
| 11 | Seam puckering (Small puckering) (Small shrinkage) | Wrinkle that occurs near stitches by shrinking by sewing, sewing slippage, etc. |  <p>The diagram shows a cross-section of cloth with a horizontal thread. A sewing machine needle is shown passing through the cloth, creating a hole. The thread is broken at the point of penetration. Labels include 'Sewing wrinkle (wavy condition)'.</p> <p>* Cloth shrinks and becomes wavy.</p> |
| 12 | Sewing slippage (Uneven material feed) | Upper and lower cloths slip each other in the feeding direction. |  <p>The diagram shows a cross-section of cloth with a horizontal thread. A sewing machine needle is shown passing through the cloth, creating a hole. The thread is broken at the point of penetration. Labels include 'Start of sewing', 'End of sewing', 'Upper cloth', 'Stitch', 'Lower cloth', and 'Sewing slippage (Uneven material feed)'.</p> |
| 13 | Left-to-right inclined stitch of bobbin thread | Left-to-right inclined stitches are formed. |  <p>The diagram shows a cross-section of cloth with a horizontal thread. A sewing machine needle is shown passing through the cloth, creating a hole. The thread is broken at the point of penetration. Labels include 'Cloth' and 'Stitch'.</p> |
| 14 | Seam grinning | Stitch opens since tension of sewing thread is insufficient. |  <p>The diagram shows a cross-section of cloth with a horizontal thread. A sewing machine needle is shown passing through the cloth, creating a hole. The thread is broken at the point of penetration. Labels include 'Upper cloth', 'Lower cloth', and 'Grinning'.</p> |

| No | Term | Definition (contents) | Contents of defect |
|----|--------------------------------------|--|---|
| 15 | Towel face | Knotting positions of sewing thread continuously occur on the lower side of cloth in the state of large thread rings. |  <p>Upper cloth Lower cloth</p> <p>Towel face</p> |
| 16 | Clogged stitch | A certain resistance force is applied to the sewing product and stitch pitch becomes irregular. |  <p>Clogged stitch Stitch Upper cloth Lower cloth</p> |
| 17 | Pitch error | Stitch length is changed by change of feed force, cloth slippage, etc. This phenomenon is apt to occur between high and low speed sewings. |  <p>Cloth Pitch error Pitch error Stitch</p> |
| 18 | Seam bray (Thread looseness) | Sewing thread gets loose and the state of stitch skipping occurs. |  <p>Seam bray Seam bray Cloth</p> |
| 19 | Hangnail | The state that several pieces of yarn of sewing thread are cut during sewing. |  <p>Needle thread Upper cloth Lower cloth Bobbin thread</p> |
| 20 | Idle stitching (Drop stitching) | Knotting point of thread is formed without sewing product. |  <p>Needle thread Upper cloth Lower cloth Bobbin thread</p> |
| 21 | Feed dog defect (Rasp-cut defect) | Scratch (trace of teeth) made by feed dog when feeding cloth. |  <p>Wrong side of cloth Feed dog defect</p> |
| 22 | Needle breakage defect | Scratch on sewing product made by needle tip when several stitches are performed in the state that needle is broken during sewing. |  <p>Needle Needle breakage defect Needle tip breakage Upper cloth Lower cloth Bobbin thread</p> |
| 23 | Needle mark (Trace of needle)) | Trace of hole of sewing machine needle due to re-sewing, basting, etc. |  <p>Cloth Needle mark</p> |